



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2940-1

Job Sheet 212336



Part No: D2940-1

Job Qty: 6 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/20/20

Job Tracking No:

Due Date: 9/23/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2940 REV D IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G 11.08.04 as per dwg rev.C DD verf:EC/IPP Rev.H 19.10.01 DWG revision (ECN 19-829) DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	9/22/20		2.00	14.29	HAAS - 1		
							HAAS - 2		
							HAAS - 3	DAS 52	
							HAAS - 4	9-89	
110	QC 2	6 pcs	9/22/20		0.00	0.00	QC 2 - 1		29/09/14
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS 52	
							QC 2 - 52	9-89	
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



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CANADA
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Container No: S300152



Part: D2940-1

Job No: 212336

Serial No/Batch: S300152

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/14/20

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	6 pcs	9/22/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Crosstubes - 2 - B4B	6 pcs	9/23/20	0.00 0.75	Crosstubes - 1 - B4B
					Crosstubes - 2 - B4B
					Crosstubes - 3 - B4B
					Crosstubes - 4 - B4B
140	QC 5	6 pcs	9/23/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9

1/20-09-15

DAS
87 SEP 18 2020
9.89

Part Op 100 - 1-Machine as per Folio FA079
 Descriptions: 110 - (QC8- Inspect parts - second check)
 120 - (QC8- Inspect parts - second check)
 130 - Per note 9 on page 1 of dwg D2940, Prep inner concave surface of support and use DT10658 apply 3M Scotch-
 Weld as per dwg. *S 206999*
 140 - (QC5- Inspect part completeness to step on W/O)
 170 - (Identify as per dwg & Stock Location: *LG051*) LOCATION : ~~EG052~~
 180 - (QC21- Final Inspection - Work Order Release)

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	5252649

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	DSK081	3	9	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490		
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510		
5	3.250 Support	1.633Inches + 0.040 - 0.000	1.673 1.633		
6	3.250 Support	1.493Inches + 0.020 - 0.000	1.513 1.493		
7	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
8	3.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
9	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
10	3.250 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
11	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
12	3.250 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
13	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
14	3.250 Support	0.350Inches + 0.100 - 0.000	0.450 0.350		
15	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
16	3.250 Support	0.150Inches + 0.020 - 0.000	0.170 0.150		
17	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
18	3.250 Support	101.640Inches + 4.000 - 0.000	105.640 101.640	103.6	
19	3.250 Support	0.260Inches + 0.007 - 0.000	0.267 0.260		
20	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
21	3.250 Support	4.118Inches + 0.020 - 0.000	4.138 4.118	4.132	

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DART AEROSPACE LTD		Work Order: 212336
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: ^{DAS} 35 9-89	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.140	0.190		0.175	0.177	0.177	0.176	0.177
AB	0.040	0.060		0.050	0.050	0.049	0.050	0.050
AC	Ø0.187	Ø0.193		0.188	0.188	0.188	0.188	0.188
AD	Ø0.260	Ø0.267		0.261	0.261	0.261	0.261	0.261
AE	0.143	0.163		0.155	0.158	0.159	0.159	0.157
AF	1.485	1.525		1.505	1.499	1.503	1.503	1.503
AG	3.510	3.530		3.523	3.524	3.522	3.516	3.521
AH	0.350	0.450		0.400	0.400	0.400	0.400	0.400
AI	4.930	4.990		4.960	4.961	4.956	4.960	4.961
AJ	0.140	0.180		0.150	0.149	0.149	0.153	0.153
AK	0.140	0.180		0.170	0.169	0.169	0.167	0.167
AL	2.322	2.342		2.332	2.332	2.332	2.331	2.332
AM	0.090	0.110		0.100	0.100	0.100	0.100	0.100
AN	0.040	0.060		0.052	0.049	0.051	0.052	0.054
AO	0.140	0.160		0.150	0.150	0.150	0.148	0.147
AP	R0.240	R0.260		0.250	0.250	0.250	0.250	0.250
AQ	R0.053	R0.073		0.063	0.063	0.063	0.063	0.063
AR	R0.053	R0.073		0.063	0.063	0.063	0.063	0.063
AS	R0.240	R0.260		0.250	0.250	0.250	0.250	0.250
AT	R0.470	R0.530		0.500	0.500	0.500	0.500	0.500
AU	R0.920	R0.980		0.950	0.950	0.950	0.950	0.950
AV								
AW								
Accept/Reject								

Measured by: ^{DAS} 52 9-89	Date: 20/09/14
Audited by: ^{DAS} 20 9-89	Date: 20-09-15
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	
F	20.02.04	Dwg Rev and dimensions updated	MCW	DP

DART AEROSPACE LTD		Work Order: 212336
Description: Ø3.250 Support	DAS 35 9-89	Part Number: D2940-1
Inspection Dwg: D2940	Rev: 1D	Page 1 of 1

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AB	0.040	0.060		0.050				
AC	Ø0.187	Ø0.193		0.188				
AD	Ø0.260	Ø0.267		0.261				
AE	0.143	0.163		0.159				
AF	1.485	1.525		1.501				
AG	3.510	3.530		3.520				
AH	0.350	0.450		0.400				
AI	4.930	4.990		4.960				
AJ	0.140	0.180		0.155				
AK	0.140	0.180		0.167				
AL	2.322	2.342		2.332				
AM	0.090	0.110		0.100				
AN	0.040	0.060		0.050				
AO	0.140	0.160		0.150				
AP	R0.240	R0.260		0.250				
AQ	R0.053	R0.073		0.063				
AR	R0.053	R0.073		0.063				
AS	R0.240	R0.260		0.250				
AT	R0.470	R0.530		0.500				
AU	R0.920	R0.980		0.950				
AV								
AW								
Accept/Reject								

Measured by: DAS 52 9-89	Date: 20/09/14
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F	20.02.04	Dwg Rev and dimensions updated	MO-MS DP	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					